Qty:

User:

Tuesday, 06/05/2008 3:49:47 PM

Julie Lecocq

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 39082

Estimate Number

: 10310

P.O. Number

This Issue Prsht Rev. : 06/05/2008

: NC

: // Previous Run

: 35977

Type

S.O. No. :

: MACHINED PARTS

Part Number

Drawing Name

: D26175

: BUSHING

Drawing Number

: D2617 REV D2

Project Number Drawing Revision

: N/A : D2

Material Due Date

: 20/05/2008

*8*ර් Um:

Each

Written By

First Issue

Checked & Approved By

Comment

: Est H 04.07.14

Reformat; added step 5 KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Tube .500 x.058W

M6061T6T0500W058 1.0

Comment: Qty.:

1.2285 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Total:

Ø0.500" tubing x 0.058" wall M6061T6T0.500W.058)

0.0205 f(s)/Unit

Batch Comp6633



2.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





10 05/05/21 160 Hm

4.0

SECOND CHECK

Comment: SECOND CHECK

5.0

HAND FINISHING1





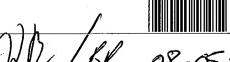
courte

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



Dart Aerospace Ltd

W/O:			٧	VORK	ORDER CHANG	ES					
DATE	STEP	PROG	CEDURE C	HANGE	4	- 1 -	Ву	By Date Qty			Approval QC Inspector
					2 9						
				١.				,		×	
Part No	:	PAR #:	_ Fault Ca	itegory:		_ NC	R: Yes	No DQ	A :	Date:	
							QA: N	/C Close	d:	_ Date: _	
NCR:		W	ORK OR	DER N	ION-CONFORMA	ANCE	(NCF	R)			
DATE	OTED	Description of NC			ective Action Secti	on B		Verifi	cation		Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng		Action Description Chief Eng	,	Sign 8 Date		ion C		QC Inspector
				-							
		H	- 1								
		· ·									

NOTE: Date & initial all entries

Tuesday, 06/05/2008 3:49:47 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: BUSHING Customer: CU-DAR001 Dart Helicopters Services Job Number: 39082 Part Number: D26175 Job Number: Seq. #: **Machine Or Operation: Description:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT ALODINE 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHAN	WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE	By Date Qty Chief			Approval Chief Eng / Prod Mgr	Approval QC Inspector		
3									
Part No	·	PAR #: Fault Category:	NCR: Yes	No DO	Δ:	Date:	1 .		

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B	Verification			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
				0.				
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				•				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39082
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617 Rev: D2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Tolerance		Accept	Reject	Method of Inspection	Comments	
+0.000/-0.010	.991	V,				
+/-0.010	.499					
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		-	1			
	+0.000/-0.010 +/-0.010	#/-0.010 . 22 \ +/-0.010 . 4/99	Tolerance Dimension Accept +0.000/-0.010 . 221	Tolerance Dimension Accept Reject	Tolerance Dimension +0.000/-0.010 ->>>	

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 08/06/11	Date: 08/05///	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.09	New Issue	KJ/JLM	
В	06.03.08	Dwg Rev change	KJ/JLM LA	
С	08.01.16	Tolerance revised for 0.500 dimension	KJ/EC/DD	- X



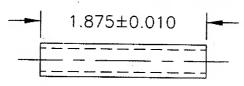


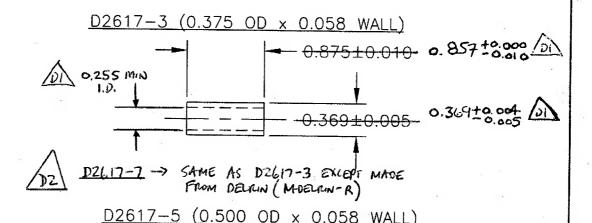
DESIGN	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	ED #	APPROVED	DRAWING NO. D2617 SHEET	REV. D
DATE			TITLE	SCALE
01.0	7.04		BUSHING	1:1
 Α		96.10.08	NEW ISSUE	

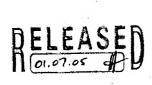
DZ 04.04.10 #192 ADD D2617-7

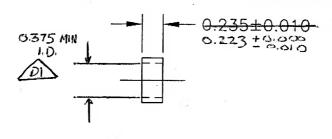
Α	96.10.08	NEW ISSUE
В	97.05.08	.875 WAS 1.125
С	97.06.04	0.369 DIA WAS 0.375
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
DI	4.07.12	CORRECT TOLERANCE (NCR 779)

D2617-1 (0.375 OD x 0.058 WALL)









SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED dOPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

NOTES:

- MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
 - OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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